



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3584-1**Job Sheet 188531****Part No:** D3584-1**Job Qty:** 7 pcs**Part Name:** Web**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 1/10/19**Job Tracking No:****Due Date:** 1/18/19**Created By:** Jesse White**Type:** SOLD**Description:****Note:** DWG REV B IPP Rev:A New Issue 07.06.12 EC**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Skidtubes - 1	7 pcs	1/18/19		0.00	4.07	Skidtubes - 1		TF
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		
							Skidtubes - 5		
110	QC 5	7 pcs	1/18/19		0.00	0.00	QC 5 - 10		BE
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 38		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
120	Handfinish - 1-1 Chemical-B4B	7 pcs	1/18/19		0.00	1.76	Handfinish - 1 - 1 - B4B		
							Handfinish - 1 - 2 - B4B		
							Handfinish - 1 - 3 - B4B		
							Handfinish - 1 - 4 - B4B		
							Handfinish - 1 - 5 - B4B		
							Handfinish - 1 - 6 - B4B		
							Handfinish - 1 - 7 - B4B		
							Handfinish - 1 - 8 - B4B		

Plex 1/10/19 12:54 PM dart.white.jesse

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION ☐ Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved		 Part: D3584-1 Job No: 188531 Serial No/Batch: S145145 Container No: S145145 Revision: Inspector: Exp Date: Instructions: Various STC's Date: 01/16/19																																																										
Date : _____ Step #: _____ Description Work Order Deviation 																																																														
Root Cause <table style="width: 100%;"> <tr> <td style="width: 50%;">☐ Environment</td> <td style="width: 50%;">☐ No Re-verification</td> </tr> <tr> <td>☐ Design</td> <td>☐ Operator</td> </tr> <tr> <td>☐ Doc/Data</td> <td>☐ Offset/Setup</td> </tr> <tr> <td>☐ Equip/Tooling</td> <td>☐ Supplier</td> </tr> <tr> <td>☐ Handling/Pre</td> <td>☐ Training</td> </tr> <tr> <td>☐ Material</td> <td>☐ Use for Testing</td> </tr> <tr> <td>☐ Internal Transport</td> <td>☐ Poor Information</td> </tr> <tr> <td>☐ Tribal Knowledge</td> <td>☐ Rushing</td> </tr> <tr> <td>☐ LOA</td> <td>☐ Product Improvement</td> </tr> <tr> <td>☐ Substation</td> <td>☐ Process Improvement</td> </tr> <tr> <td>☐ Past Expiry Date</td> <td>☐ Manufacturing Process</td> </tr> <tr> <td>☐ Misidentified</td> <td>☐ Past Due</td> </tr> </table>		☐ Environment	☐ No Re-verification	☐ Design	☐ Operator	☐ Doc/Data	☐ Offset/Setup	☐ Equip/Tooling	☐ Supplier	☐ Handling/Pre	☐ Training	☐ Material	☐ Use for Testing	☐ Internal Transport	☐ Poor Information	☐ Tribal Knowledge	☐ Rushing	☐ LOA	☐ Product Improvement	☐ Substation	☐ Process Improvement	☐ Past Expiry Date	☐ Manufacturing Process	☐ Misidentified	☐ Past Due	FAULT CATEGORY <table style="width: 100%;"> <tr> <td style="width: 33%;">☐ Pressure/Forced</td> <td style="width: 33%;">☐ Temperature/Cure</td> <td style="width: 33%;">☐ Power Loss/Surge</td> </tr> <tr> <td>☐ Bending</td> <td>☐ Set-up</td> <td>☐ Folio/Program</td> </tr> <tr> <td>☐ Centre Not Concentric</td> <td>☐ BOM/Route</td> <td>☐ Grain</td> </tr> <tr> <td>☐ Cracks</td> <td>☐ Broken/Damage/Defect</td> <td>☐ Weld</td> </tr> <tr> <td>☐ Crimp/Kink/Ripple/Wave</td> <td>☐ Inspection Incomplete/Unqualified</td> <td>☐ Wrong Stock Pulled</td> </tr> <tr> <td>☐ Cuffs</td> <td>☐ Contamination</td> <td>☐ Out of Sequence</td> </tr> <tr> <td>☐ Crushing</td> <td>☐ Countersink</td> <td>☐ Off-set</td> </tr> <tr> <td>☐ Heat Treat</td> <td>☐ Cut Too Short</td> <td>☐ Mislabeled</td> </tr> <tr> <td>☐ Wave/Twist in Tube</td> <td>☐ Instructions Incomplete/Unclear</td> <td>☐ Fit/Function</td> </tr> <tr> <td>☐ Marks/Chatter</td> <td>☐ Drill Holes</td> <td>☐ Misaligned/off center</td> </tr> <tr> <td colspan="3">☐ OTHER :</td> </tr> </table>				☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Crushing	☐ Countersink	☐ Off-set	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ OTHER :		
☐ Environment	☐ No Re-verification																																																													
☐ Design	☐ Operator																																																													
☐ Doc/Data	☐ Offset/Setup																																																													
☐ Equip/Tooling	☐ Supplier																																																													
☐ Handling/Pre	☐ Training																																																													
☐ Material	☐ Use for Testing																																																													
☐ Internal Transport	☐ Poor Information																																																													
☐ Tribal Knowledge	☐ Rushing																																																													
☐ LOA	☐ Product Improvement																																																													
☐ Substation	☐ Process Improvement																																																													
☐ Past Expiry Date	☐ Manufacturing Process																																																													
☐ Misidentified	☐ Past Due																																																													
☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge																																																												
☐ Bending	☐ Set-up	☐ Folio/Program																																																												
☐ Centre Not Concentric	☐ BOM/Route	☐ Grain																																																												
☐ Cracks	☐ Broken/Damage/Defect	☐ Weld																																																												
☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled																																																												
☐ Cuffs	☐ Contamination	☐ Out of Sequence																																																												
☐ Crushing	☐ Countersink	☐ Off-set																																																												
☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled																																																												
☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function																																																												
☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center																																																												
☐ OTHER :																																																														

					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	D.R 19/01/17
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					2Handfinish - 1 - 22 - B4B	
130 QC 7	7 pcs	1/18/19	0.00	0.00	QC 7 - 10	
					QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	BE
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 38	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 6	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
140 Packaging 3-1 - Stock - B4B	7 pcs	1/18/19	0.00	0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	TF
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
150	QC 21 - SA	7 pcs	1/18/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
Part Op 100 - 1-Cut to Length as per Dwg D3584 2-Drill Pilot Holes using DT8960 Drill Jig 3-Open pilots to 1.000" as per Dwg Descriptions: D3584 4-Deburr 110 - (QC5- Inspect part completeness to step on W/O) 120 - (Chemical Conversion Coat per QSI005 4.1) 130 - (QC7-Inspect Chemical Conversion Coat) 140 - (Identify as per dwg & Stock Location: <u>LG002</u>), LOCATION : LG002 150 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
D2963-125	105 I-Beam Extrusion	7 pcs (1 ea)	100-Skidtubes - 1	B156872	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Skidtubes - 1	D2963-125	7	80	0	
Part Specifications					
Specifications could not be found.					

Plex 1/10/19 12:54 PM dart.white.jesse

DQA: _____ Date: _____

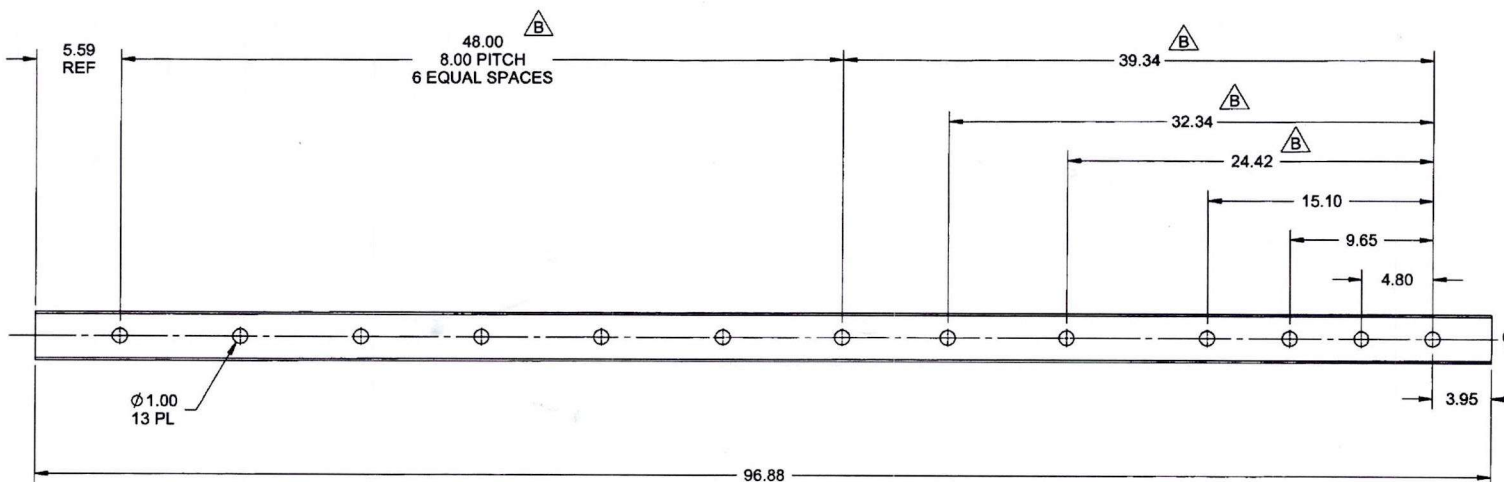


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By																																																									
								Lead hand / Supervisor Approval Verification																																																									
								QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																



D3584-1 WEB

RELEASED
2015-06-08
EN 15-651

- NOTES:**
- 1) MATERIAL: MAKE FROM D2963-125 EXTRUSION
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.010 TO 0.020
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 5.08 lbs

APPROVED

B	24.42 WAS 23.42, 32.34 WAS 31.34 & (48.00 WAS 56.00 (ZN C3-1 & C6-1); ADDED 39.34	RF	15.02.20
A	NEW ISSUE	PH	07.06.08
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	RF	DRAWING NO.	REV. B
CHECKED	VS	D3584	SHEET 1 OF 1
MFG. APPR.	JLM	TITLE	SCALE
APPROVED	HS	WEB	NTS
DE APPR.	DS	DATE 15.02.20	

COPYRIGHT © 2007 BY DART AEROSPACE USA, INC.
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coor. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QS1042) Approval	
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
		OTHER : ☐							